IS 6835 (1973): Drifts [PGD 6: Earth, Metal And Wood Working Hand Tools]

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UDC 621·961·4

(Reaffirmed 2006)

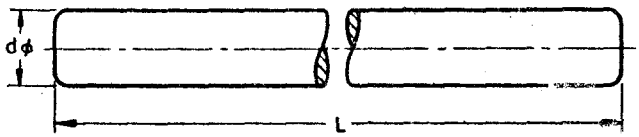
Indian Standard

SPECIFICATION FOR DRIFTS

1. Scope — Lays down the requirements for brass and steel drifts.

2. Dimensions

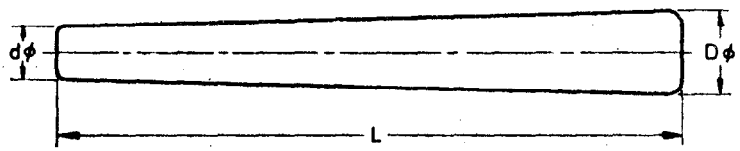
2.1 *Brass Drifts*



All dimensions in millimetres.

Nominal Size	*d* +0·03 −0·08	*L* ±3
10	10	160
12·5	12·5	160
20	20	160
25	25	200

2.2 *Steel Drifts*



All dimensions in millimetres.

Nominal Size	*d* +0·03 −0·08	*D*	*L* ±3
5	5	8	100
8	8	14	140
14	14	22	165
19	19	29	185
25	25	35	215

2.3 *Tolerances* — Tolerances on untoleranced dimensions shall be according to best prevalent manufacturing practices.

3. Material — The brass drifts shall be manufactured from brass conforming to CuZn40 of IS : 4170-1967 ' Brass rods for general engineering purposes '. The steel drifts shall be manufactured from steel conforming to grade C55Mn^{75} of IS : 2073-1962 ' Carbon steel bars for production of machined parts for general engineering purposes '.

4. Hardness — The steel drifts shall have a hardness of 350 to 400 *HV* [*see* IS : 1501-1968 Method for Vickers hardness test for steel (*first revision*)].

5. Workmanship and Finish — The drifts shall be free from cracks, pits, flaws, seams, burrs and other defects. All sharp corners and edges shall be removed. The drifts shall be slightly rounded at the edges.

Adopted 2 February 1973 | | Gr 1

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6. Designation — The drifts shall be designated by the commonly used name, nominal size and the number of this standard. A brass drift of nominal size 10 mm shall be designated as:

Brass Drift 10, IS : 6835

7. Preservation and Packing — The drifts shall be suitably packed in accordance with the best prevalent trade practice.

8. Marking — The drifts shall be marked with the nominal size, manufacturer's name, initials or recognized trade-mark.

8.1 *ISI Certification Marking* — Details available with the Indian Standards Institution.

9. Tests

9.1 The brass drifts shall be held upright vertically on a block of lead. Three full blows shall be given at the top end of the brass drift with a hide faced hammer having a weight of 780 g approximately. The brass drifts shall not show any sign of damage or distortion on completion of the test.

9.2 The steel drifts when given six hard blows with 500 g hammer on one end, the other end resting vertically on a mild steel block shall show no sign of distortion or crack on completion of the test.

EXPLANATORY NOTE

This standard deals with the brass and steel drifts used by fitters for pushing out the axle from the hole of a wheel or pinion or similar other objects during assembly or maintenance work. Brass drifts are used on soft and delicate components while steel drifts are used on sturdy and heavy components. While preparing this standard, assistance has been derived from the Specification on drifts issued by the Chief Inspectorate of General Stores, Kanpur.